

Del 1.25

Work Order ID 75054

75054

Page 1

Item ID: D3417-7

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Washer

Stop *NS2*

Start Date: 17/10/2011 Start Qty: 20.00

20

Cust Item ID:

Required Date: 28/10/2011 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: M.C.J

Date: 11/10/12

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3417

Rev E

F

100

0.00

100

Hardinge CNC LATHE SMALL

Doosan

Memo

0.00

Doosan Lathe

1-Turn as per Folio FA

Rev: ~~E~~ & Dwg D3417 Rev: ~~E~~

2-Deburr

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

20 ϕ

10/10/16

20 ϕ

10/10/16

20 ϕ

B.A 11/11/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 75054***75054***

Page 2

Item ID: D3417-7

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Washer

Start Date: 17/10/2011 Start Qty: 20.00

20

Cust Item ID:

Required Date: 28/10/2011 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location **ST 53** 0.00***130***

Packaging

Memo

0.00

Packaging

20X **SP** **11-11-18**

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

11/11/21**11-11-18**
60

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October-17-11 10:39:54 AM

Page 1

Work Order ID: 75054

75054

Parent Item: D3417-7

D3417-7

Parent Item Name: Washer

Start Date: 17/10/2011

Required Date: 28/10/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDEL RINR1.2500		Purchased	No			100	f	30.6390	0.0296	0.623158			
MDFI RINR1 2500										**	SA W/W16		
DEL RIN ROUND BAR 1.25"													

Location

MAT055

114586

119133

Loc Qty

30.639

6.639

24

Loc Code

75054

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

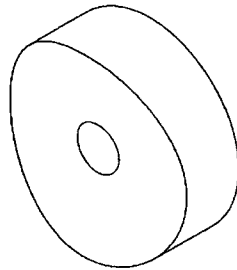
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

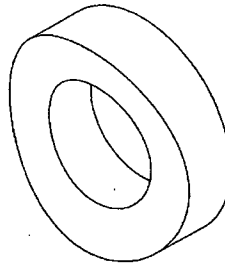
SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 75054

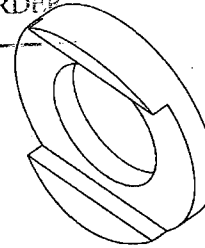
11-10-17



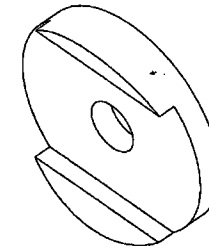
D3417-1 WASHER



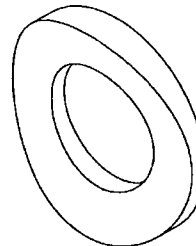
D3417-3 WASHER



D3417-5 WASHER



D3417-7 WASHER



D3417-9 WASHER

RELEASED
2010-09-15

NOTES:

1) MATERIAL: BLACK DELRIN II 150E OR ACETRON GP ACETAL, ROD
REF DART SPEC M-DELRIN-R
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, BAR
REF DART SPEC M-DELRIN-B
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, SHEET
REF DART SPEC M-DELRIN-S

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: D3417-1, 0.020 lbs

D3417-3, 0.010 lbs

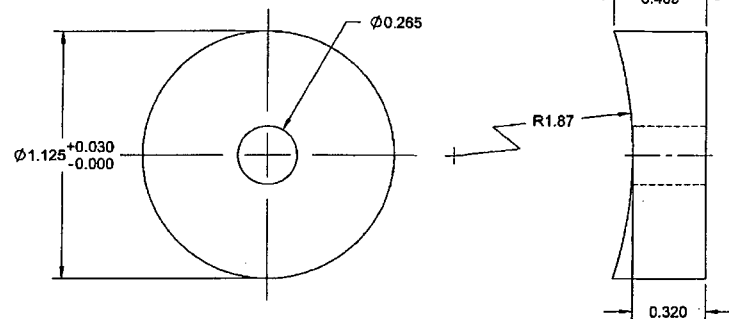
D3417-5, 0.010 lbs

D3417-7, 0.010 lbs

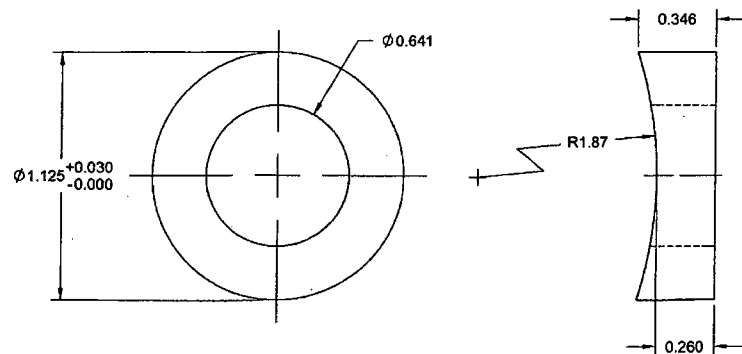
D3417-9, 0.004 lbs

F	ADD D3417-9 (ZN B5-3)	SC	10.07.26
E	ADD D3417-7 (ZN A2-2)	RF	09.08.30
D	ADD -S WASHER (ZN B2-1, B2-2); REFORMAT TO 'B' SIZE & UPDATE TO CURRENT STANDARDS; REASON: INSTALLATION OF NEW TOW RING	AJS	08.07.08
C	REMOVE CBORE, WIDEN	PH	05.06.30
B	CHANGE TO ROUND WASHER	PH	05.06.10
A	NEW ISSUE	PH	05.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3417	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WASHER	NTS
DATE	10.07.26	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS COVENANT THAT IT NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

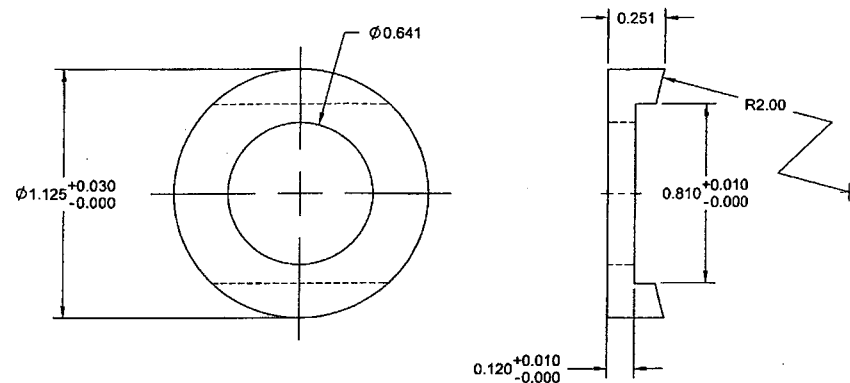
75054



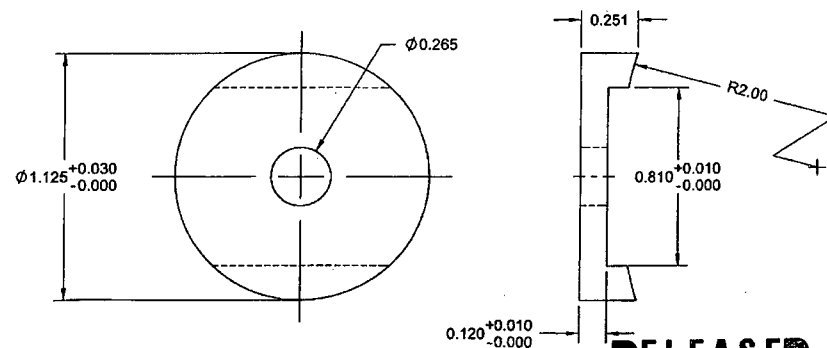
D3417-1 WASHER



D3417-3 WASHER



D3417-5 WASHER



D3417-7 WASHER

RELEASED
R 2010-09-15

DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO. D3417	REV. F
MFG. APPR.		TITLE WASHER	SHEET 2 OF 3
APPROVED			SCALE NTS
DE APPR.			
DATE	10.07.26	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR DISCLOSED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

